

Date: Friday, 5/25/2007 8:17:59 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 32592		
Estimate Number	: 11446		
P.O. Number	:	Part Number	: D3391013
This Issue	: 5/25/2007 S.O. No. :	Drawing Number	: D3391 REV. <i>FLG u</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: F
Previous Run	: 32591	Material	:
Written By	:	Due Date	: 6/20/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>KJ 0705.28</i>		
Comment	: Est. A 05.12.13 New Issue EC Est. B 06.02.09 Dwg rev.D EC Est Rev:06-03-28 Update Manufacturing Instructions JLM est rev D 07.03.14 dwg Rev F EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	

*B24593 DP 7-7-13*

2.0	D3391011	Fwd Tube Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch: \_\_\_\_\_

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Drill pilot holes including "B" holes using DT8796 as per Dwg D3391

3-Open float bag holes as per Dwg D3391

4-C'sink float bag holes as per Dwg D3391

5-Open remaining holes as per dwg D3391

6- Locate electric step holes 41.0000" from fwd end and drill using DT 8393

\*\*\*\*\* ensure step holes are on top of tube not bottom Pat\*\*\*\*\*

*DP 7-7-13**DP 7-7-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 32592

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 7- Open electric step holes 0.332" per dwg D3391 (section L-L)
- 8- Open electric step holes 0.250" per dwg D3391 (section M-M)
- 9- Open electric step holes 0.250" per dwg D3391 (section LL-LL)
- 10- Remove .030" from Fwd indexing Ridge as per Dwg D3391
- 11- Remove indexing ridge on Fwd & Aft end of skid tube as per Dwg D3391
- 12- Deburr
- 13- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.208" holes with paint marker
- 14- Open wearplate holes of D3391-013 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391
- 15- Open wearplate holes of D3391-013 assembly detail section H-H to Ø0.257" and c'sink (20 holes) as per Dwg D3391
- 16- Open .375" holes to .438"
- 17- insert D3391-011 and click in place with wearplate holes, transfer drill saddle holes as per dwg D3391.
- 18- Deburr and blow out all chips from inside tube

DD  
27-A  
DTC

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1  
Touch-up alodine in D3391-011

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-01-21	3.0	<p>Tube is scrap. Incorrect instruction to drill @ 41.0" on the estimate. Should be 41.5 from the aft + end. Dwg is correct.</p> <p>RC: incorrect measurement on the estimate.</p>	<p>Initial: [Signature]</p> <p>Final: [Signature]</p>	<p>estimate is corrected</p> <p>scrap &amp; destroy mid-tube</p> <p>NO replace</p>	<p>[Signature]</p> <p>8-1-22</p>		<p>[Signature]</p> <p>8/1/21</p>	<p>[Signature]</p> <p>8/1/21</p>

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32592

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D33891

Web



Comment: Qty: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3389-1	Web	
---	---------	-----	--

A/R Sikaflex-241/-291

Sikaflex expire date:

Start: Time:

Finish: Time:

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

\*\*\*\*\*Ensure Web Aligment \*\*\*\*\*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Use paint screws to mask inserts.

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

NAS1330C3KB116

Insert



Comment: Qty: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

24	NAS1330C3KB116	Insert	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32592

Part Number: D3391013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	NAS1330C3KB166	INSERT
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

RivnuT

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

24	NAS1330C3KB166	Insert	
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14.0	NAS1329C4KB140	INSERT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	NAS1329C4KB140	Insert	
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15.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	NAS1515H3L	Washer	
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16.0	AN960C10L	washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	AN960C10L	Washer	
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17.0	NAS1515H4L	Inventory ,
------	------------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	NAS1515H4L	Washer	
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18.0	AN960C416L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	AN960C416L	Washer	
---	------------	--------	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Drawing Name: MID TUBE ASSEMBLY

Job Number: 32592

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

MS27039C109

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039C1-09 Screw

20.0

MS27039C408

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039C4-08 Screw SCREW

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Assemble as per dwg D3391

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 080.22

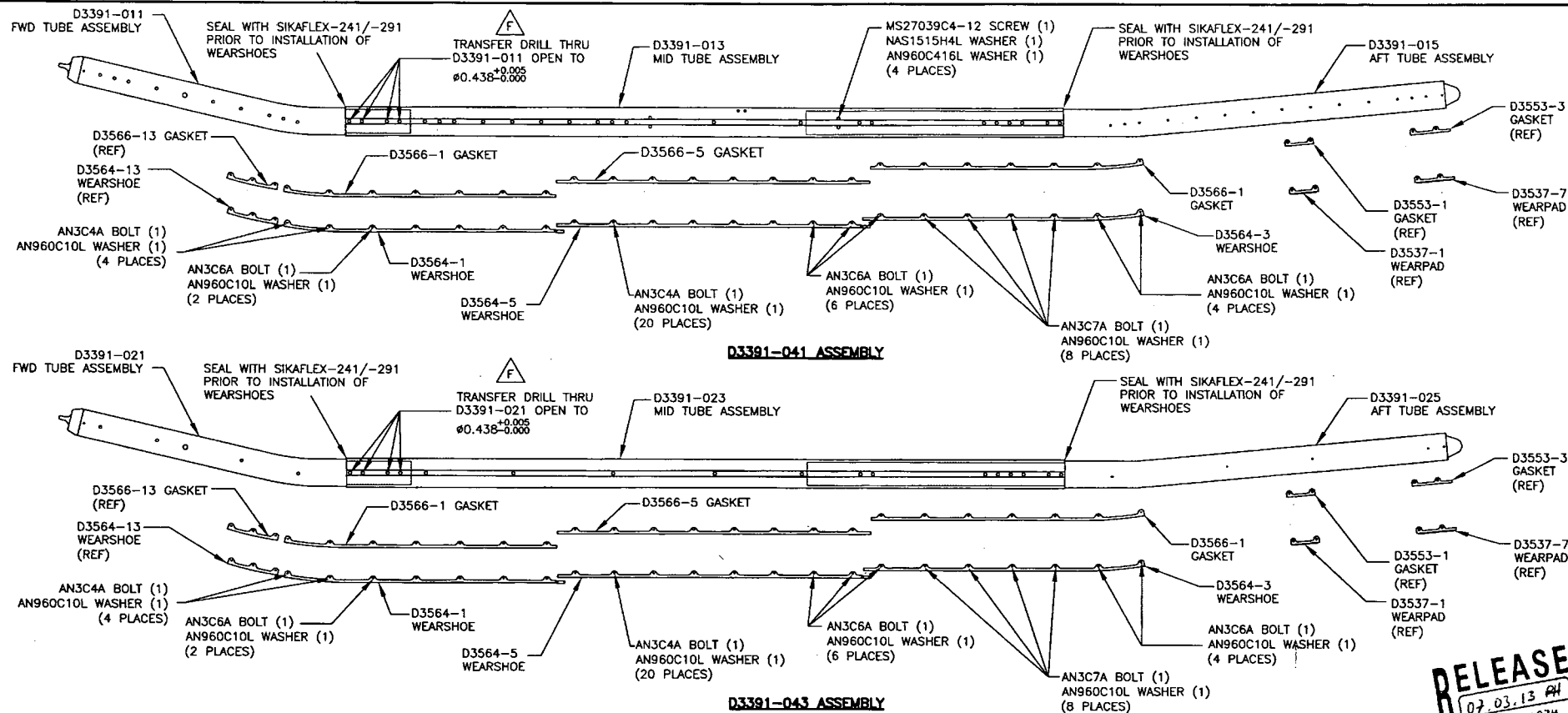
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**RELEASED**  
07.03.13 RH  
FOR ECU #934

# **D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER

## **GENERAL NOTES**

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.  
USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø.250-Ø.257) FOR WEARSHOE INSERTS. C'SINK Ø.391/Ø.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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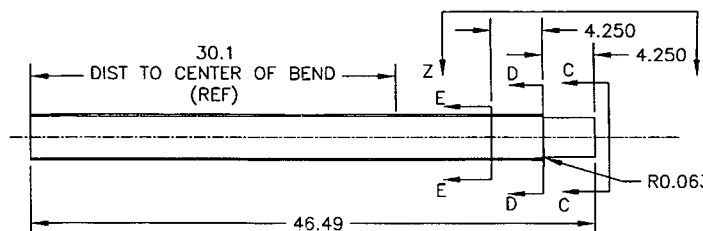
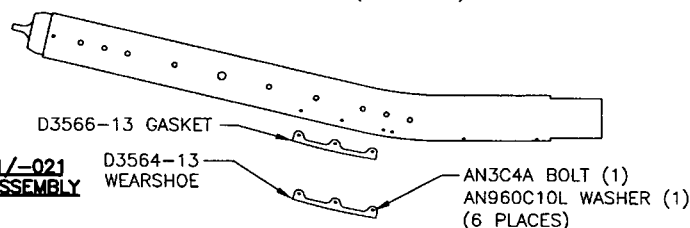
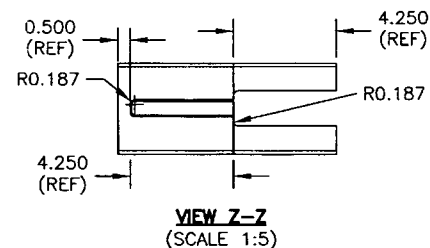
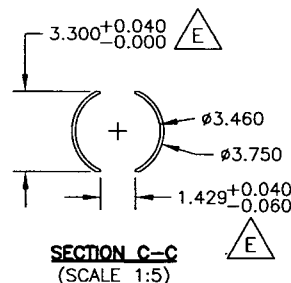
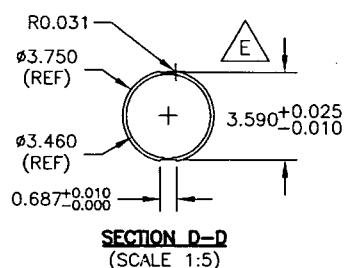
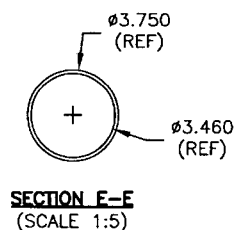
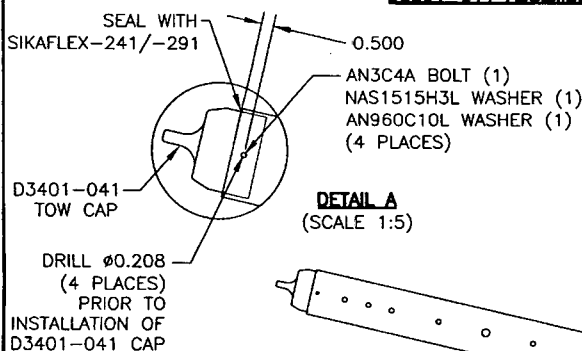
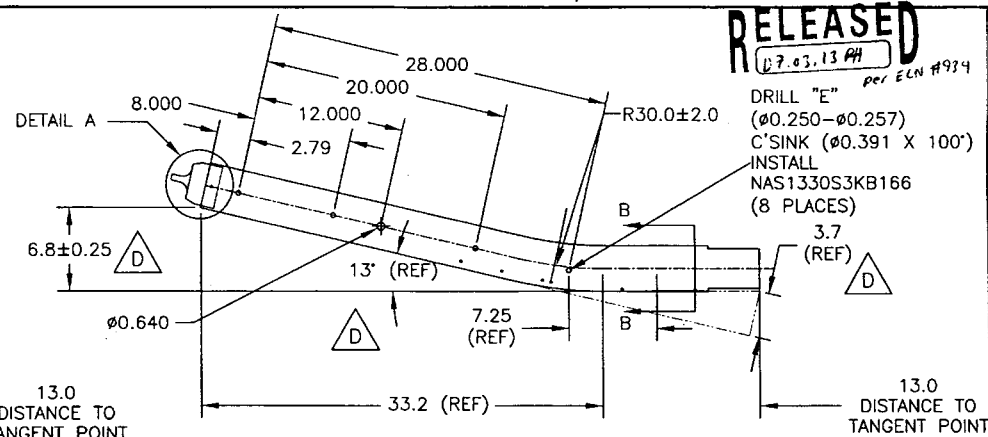
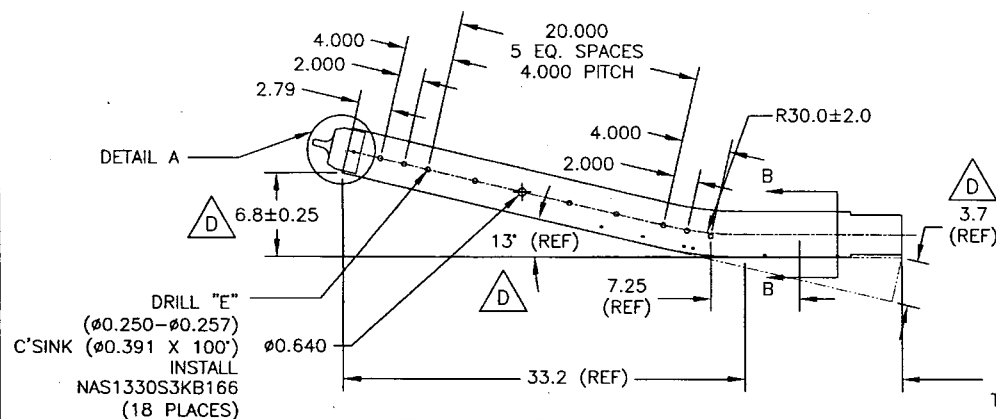
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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		D3391
		412 FLOAT SKIDTUBE
		REV. F
		SHEET 1 OF 5
		SCALE
		NTS

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PORT HADLOCK, WA

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**RELEASED**  
 07.03.13 PH  
 per ECLN #9314



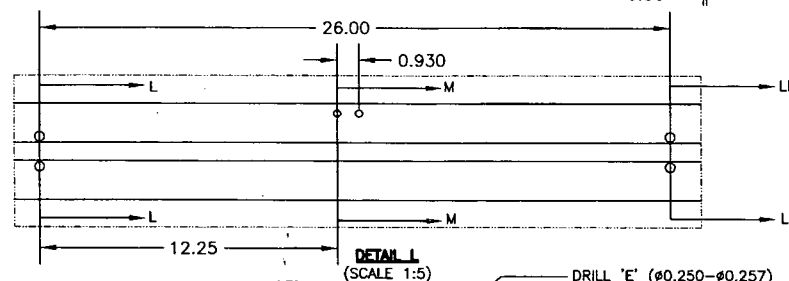
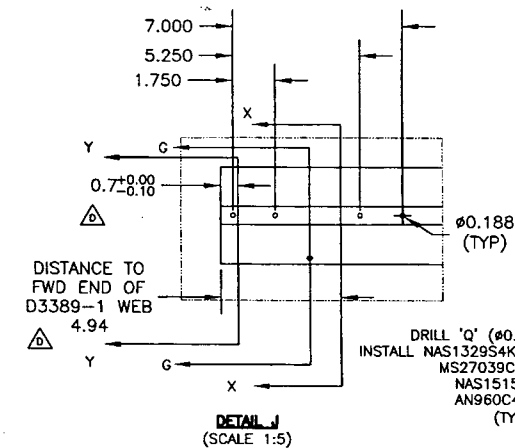
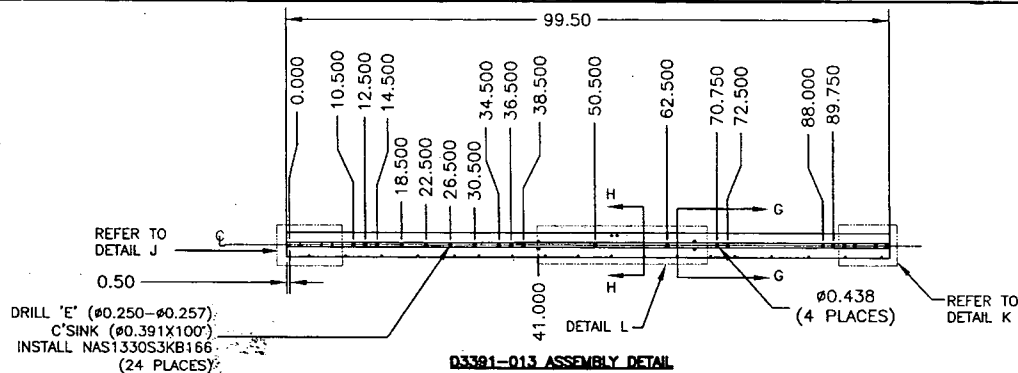
**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

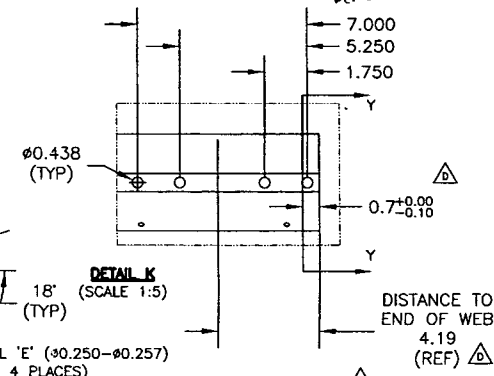
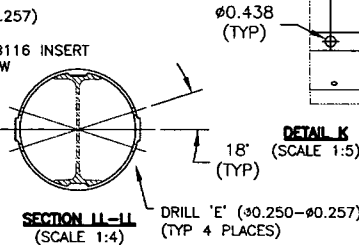
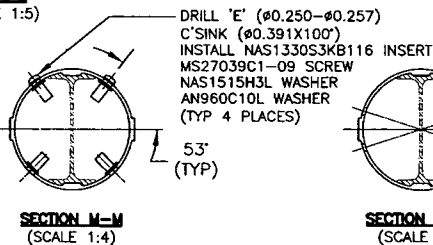
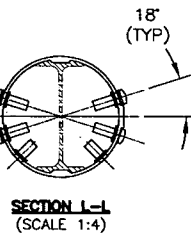
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5  
 DRILL "E"  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100')  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 2 OF 5 SCALE 1:10



DRILL 'Q' (#0.332-#0.338)  
INSTALL NAS1329S4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



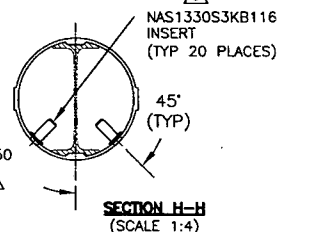
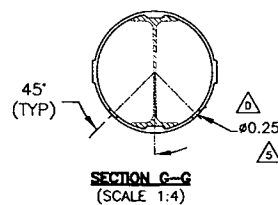
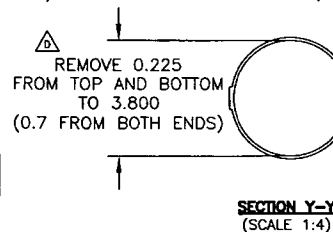
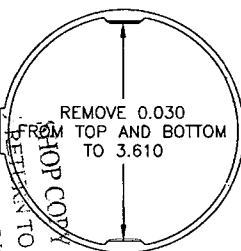
# **D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

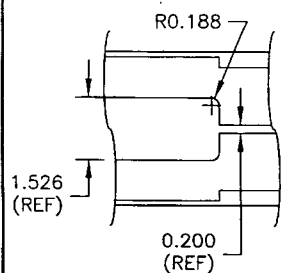
## **D3391-013/-023 MID TUBE ASSEMBLY**

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

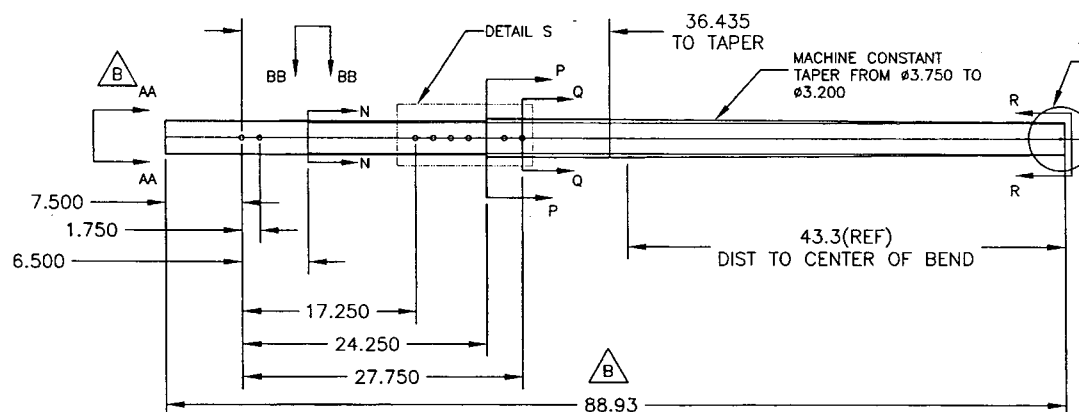
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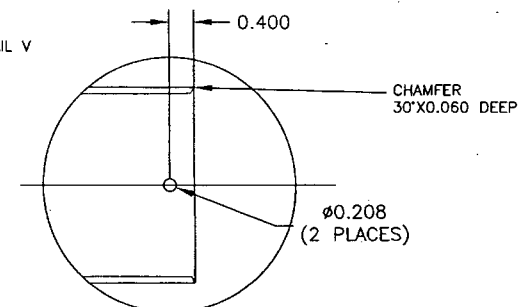
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		DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE		SCALE 1:20



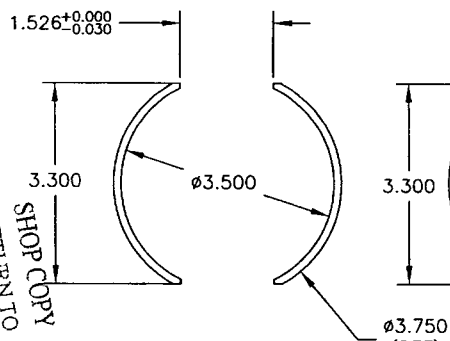
VIEW BB-BB  
(SCALE 1:3)



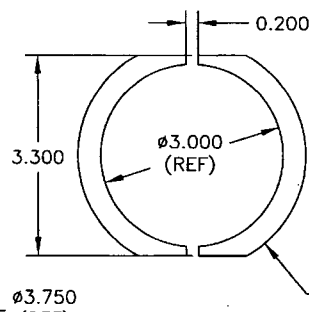
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



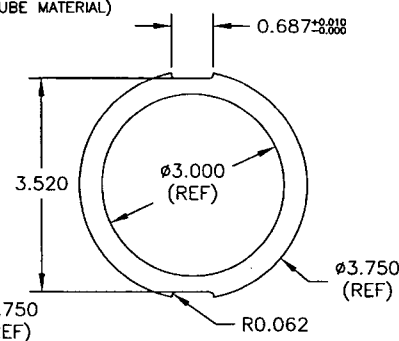
DETAIL V  
(SCALE 1:2)



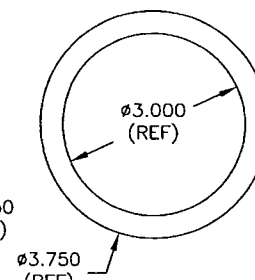
SECTION AA-AA  
(SCALE 1:2)



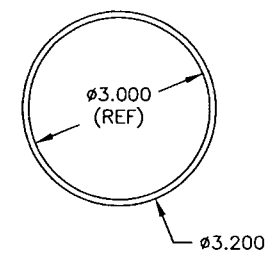
SECTION N-N  
(SCALE 1:2)



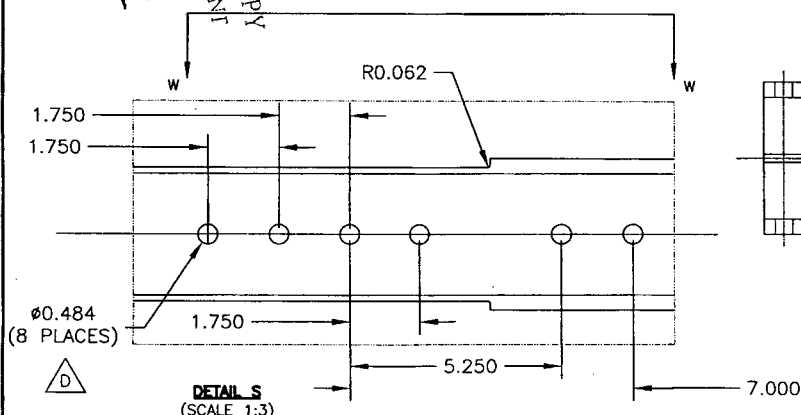
SECTION P-P  
(SCALE 1:2)



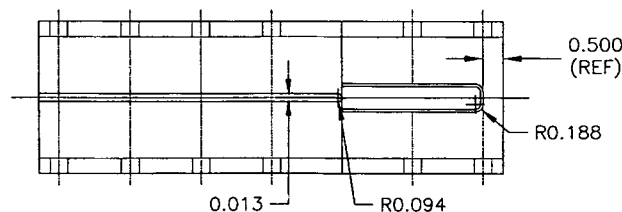
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)

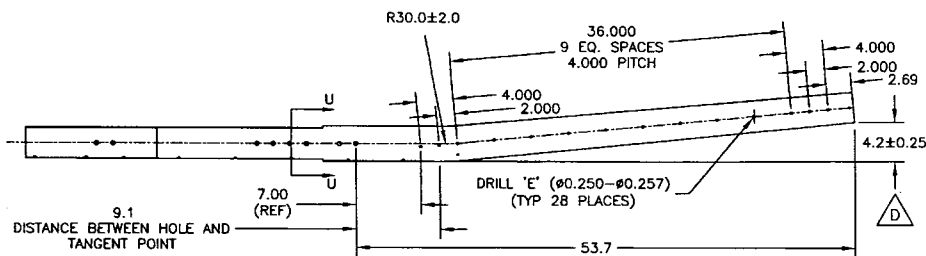


VIEW W-W  
(SCALE 1:3)

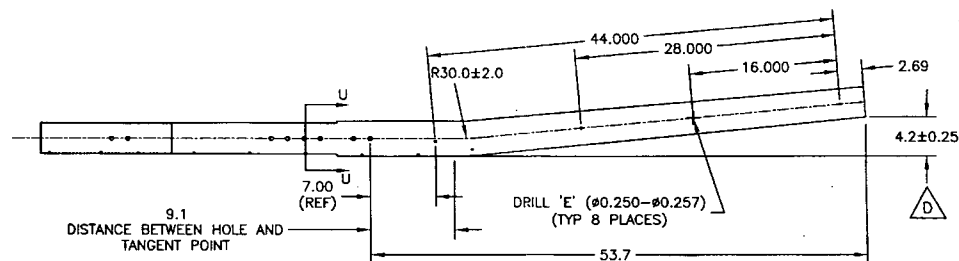
RELEASED  
07.03.13 PH  
PER ECU #934

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DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE		SCALE 1:12		

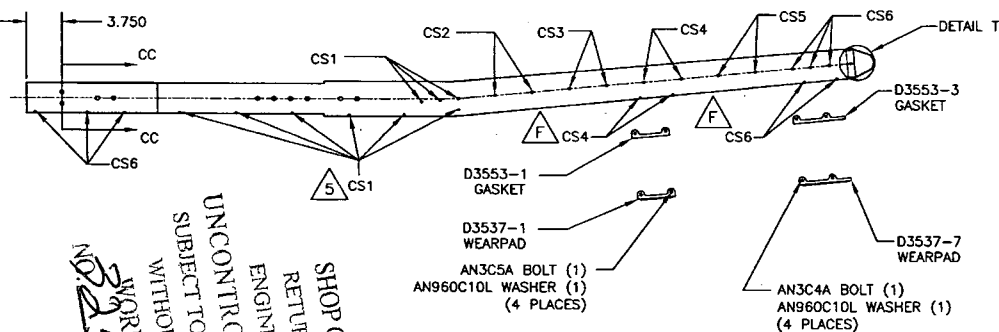
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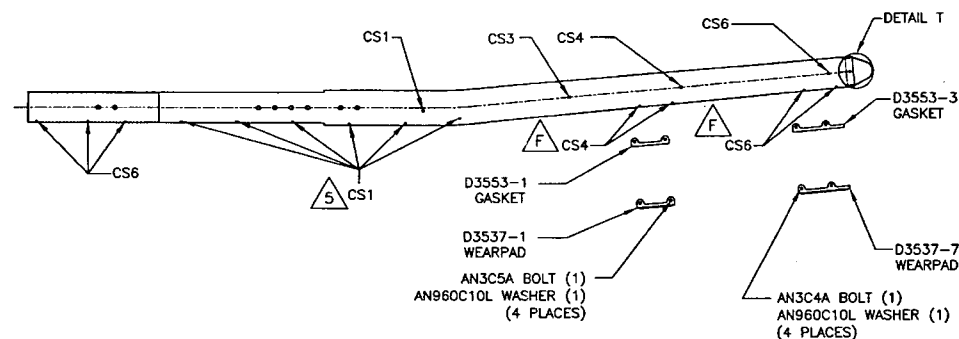
**D3391-015 BENDING AND ASSEMBLY DETAIL**



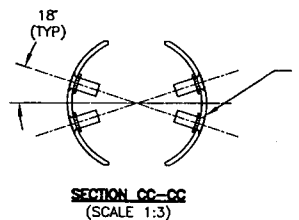
**D3391-025 BENDING AND ASSEMBLY DETAIL**



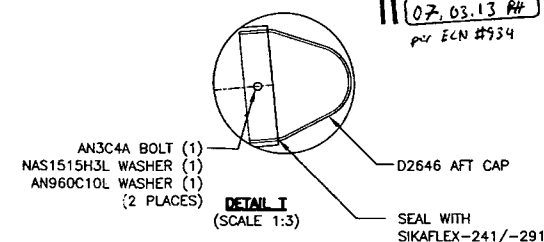
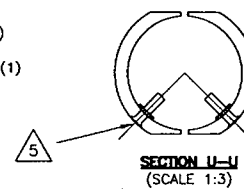
**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



DRILL 'Q' (Ø0.332-Ø0.338)  
C'SINK (Ø0.529X100")  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DATE	07.01.18	TITLE	412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

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07.03.13 PA  
per ECN #734